



portions having a tapped hole for tightening a copper plate, where a shortage or cooling is caused to be present, the widths of the slit grooves are widened at portions where the cooling should be strengthened, the water flowing resistances of the cooling water at the portions are reduced, and the velocity of the cooling water is prevented from being slowed down.

(2) Cumbersome positioning operations can be simplified when cutting or machining the slit grooves in a copper plate that becomes a cooling plate, wherein it is possible to reduce the production costs.

(3) By making uniform the cooling efficiency over the entirety of the cooling plate by adjusting the pressure loss and flow quantity of cooling water streaming in respective slit grooves, the thermal expansion can be made uniform to prevent strains of the cooling plate from occurring. And, break-out and defects of molded pieces in the continuous casting of molten metal can be prevented from occurring, wherein the yield of the molded pieces can be improved.